,												
Work Orde Friday, June 04,												Page 1
Revision ID:	D4005-041 Fwd Floor Gut	tter		lh.	Accept				 	Setup Star Stop	1 30011101 0	
	6/4/2010	Start Qty: Req'd Qty			·	Cust Item I Customer:	D:			,		1818 118 1181 1881
Approvals:	Process Plan	n:	/	Date:	7 Tooling: SPC (Y/N):		ate:		, F	Run Star Sto _l		
Sequence ID/ Work Center ID		Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D4005	Revi	ision Nbr				·.						
100 Waterjet		M	emo		0.00				1810	~6~1U		
FLOW CNC Waterje	540	. D	Cut as per wg Rev:og Rev:					•:	i y		\bigcirc	

0.00

0.00

HB10-6-1U

2-Deburr if necessary

QC2- Inspect parts off machine FAI/FAIB

Memo

110

Quality Control

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W/O:			V	VORK ORDER CHAN	IGES					t s
DATE	STEP	PRO	OCEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:								
	Res	olution:							Date:	
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DATE	STEP	TEP Description of NC						cation	Approval	Approval
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				·						1.

Work Order ID 59504

Friday, June 04, 2010 3:01:56 PM



Page 2

Item ID:

D4005-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Fwd Floor Gutter

Start Date:

6/4/2010 Start Otv: 1.00

Required Date: 6/10/2010

Req'd Oty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

OC:

Process Plan:

Date: _____

Date: _____

Tooling:

SPC (Y/N):

Date:

Date:

Run

Stop



Sequence ID/ Work Center ID

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/ **Run Hours**

0.00

Tool ID

Tool # Plan Code Accept Oty

Reject Qty

Reject Insp. Number Stamp

130



Brake NC

Brake NC

Bend as per dwg

0.00

SB W06/28



Quality Control

QC5- Inspect part completeness to step on W/O

Bend D4005-13 as per Dwg

Memo

Memo

	•									₹
W/O:			V	VORK ORDER CHANG	GES	10.12				,
DATE	STEP	PRO	OCEDURE CH	IANGE	l	Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC			Section B on Sign &			ation	Approval	Approval
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Work Order ID 59504

Friday, June 04, 2010 3:01:56 PM



Page 3

Item ID:

D4005-041

Accept



Setup Start

Stop



Revision ID:

Item Name:

Fwd Floor Gutter

Start Date: 6/4/2010 Required Date: 6/10/2010

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID: Customer:

Reference:

	_	
Δn	provals:	
4 2 1	provais.	

Process Plan:

Date:____

Tooling:

Date:

Tool # Plan

Code

Start Run

Reject

Qty

QC:

Date:

SPC (Y/N):

Set Up/

Date:

Stop

Accept

Qty

Number Stamp

Insp.

Sequence ID/

Work Center ID

Large Fab

141

Large Fab

Operation Description

Run Hours Weld per dwg A/R Aluminum rod Batch: M/12860 0.00

Memo

Memo

1- Weld D4003-13 tube to angle as per dwg D4005

2- grind flush as per dwg

Tool ID

142

OC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

0.00

0.00

1 D BE10/1/18

Reject

143

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

W/O:	<u> </u>		WC	RK ORDER CHANG	GES	, , , , , , , , , , , , , , , , , , , ,				,
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Work Order ID 59504

Friday, June 04, 2010 3:01:56 PM



Page 4

Item ID:

D4005-041

Accept

Setup Start

Stop



Revision ID:

Fwd Floor Gutter Item Name:

Required Date: 6/10/2010

Start Date:

6/4/2010

Start Oty: 1.00

Reg'd Qty: 1.00



Cust Item ID: Customer:

Reference:

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	μμ	ıv	٧a	13	

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date: Date: Run

Start Stop



Sequence ID/

Work Center ID

150

HandFinish

Operation Description

Chemical Conversion Coat per OSI005 4.1

Set Up/ **Run Hours**

0.00

Tool ID

Tool # Plan Code

Accept Reject Oty Qty

Reject Number

Insp. Stamp

Hand Finishing

Memo

0.00

1 Bl 10-11-18

160

Powdercoat

Powder Coating

Grey Sandtex(Ref: 4.3.5.6) per QSI005 4.3

0.00

0.00

1 Bl. 10-11-19

170

QC3- Inspect Part Finish

0.00

= 2) No (ul 19

Memo

0.00

Quality Control

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W/O:			W	ORK ORDER CHAI	NGES					r ,
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Work Order ID 59504

Friday, June 04, 2010 3:01:56 PM



Page 5

Item ID:

D4005-041

Accept



Setup Start

Stop



Revision ID:

Item Name: Fwd Floor Gutter

Required Date: 6/10/2010

Start Date:

6/4/2010

Start Oty: 1.00

Req'd Qty: 1.00



Cust Item ID: Customer:

Reference:

A		ala.
ΑD	prov	ais:

Process Plan:

Date:

Tooling:

Date:

Tool ID

Run Start



OC:

Date: _____

SPC (Y/N):

Date:

Tool # Plan

Code

Stop



Sequence ID/ Work Center ID

190

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location: // 0

Memo

Set Up/ **Run Hours**

0.00

0.00

Accept Reject

Qty

Reject Qty Number

Insp. Stamp

200

OC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Ch 10/11/22 70/ NWF 10-11-22

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W/O:			WO	RK ORDER CHANG	ES				
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Picklist Print

Friday, June 04, 2010 3:02:00 PM

Work Order ID: 59504

Parent Item:

D4005-041

Parent Item Name:

Fwd Floor Gutter

Comments:

IPP rev A 10.01.21 new issue Prelim EC verified by:DD 10.05.03 as per ECN10-562 DD verified by:EC

Start Date: 6/4/2010

Required Date: 6/10/2010

Page 1

Start Oty: 1.00

Required Oty: 1.00

Component Item ID/ Item Name M2024T3S.040	Replacement Item ID	Mfg/ Purch Purchased	Bin Item No	Primary Location	Last Location	Route Seq ID 100	Unit of Measure sf	Qty on Hand 436.0000	Qty per Kit	Total Otv 0.442105	Qty Issued	Date Issued	Status
2024-T3 .040 sheet											JB10-	6-(C	
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					112291		32						
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D4003-13 		Manufactured	No			141	Each	1.0000		1 fl	10. j	0.2	5
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IPP Rev:B

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DART AEROSPACE LTD	Work Order:	59504
Description: FWD Floor GUTTED	Part Number:	D4005-041
Inspection Dwg: PHOG-13 Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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4.00	7 630	3,999	*			
1.75	4 .30	1,744	*	ļ		
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2.26	TL . 550	2.363	1			
1.87	4 30	1.874	*			
3.10	4 .30	3.675	*			
4.12	7- ,030	4,100	4			
9.08	4 .00	9.074	4			
7.13	7L 330	9134	0			
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Measured by:	iB.	Audited by:		Prototype Approval:	N/A
Date:	10-6-10	Date:	10/06/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	- Julia	New Issue	KJ/JLM	

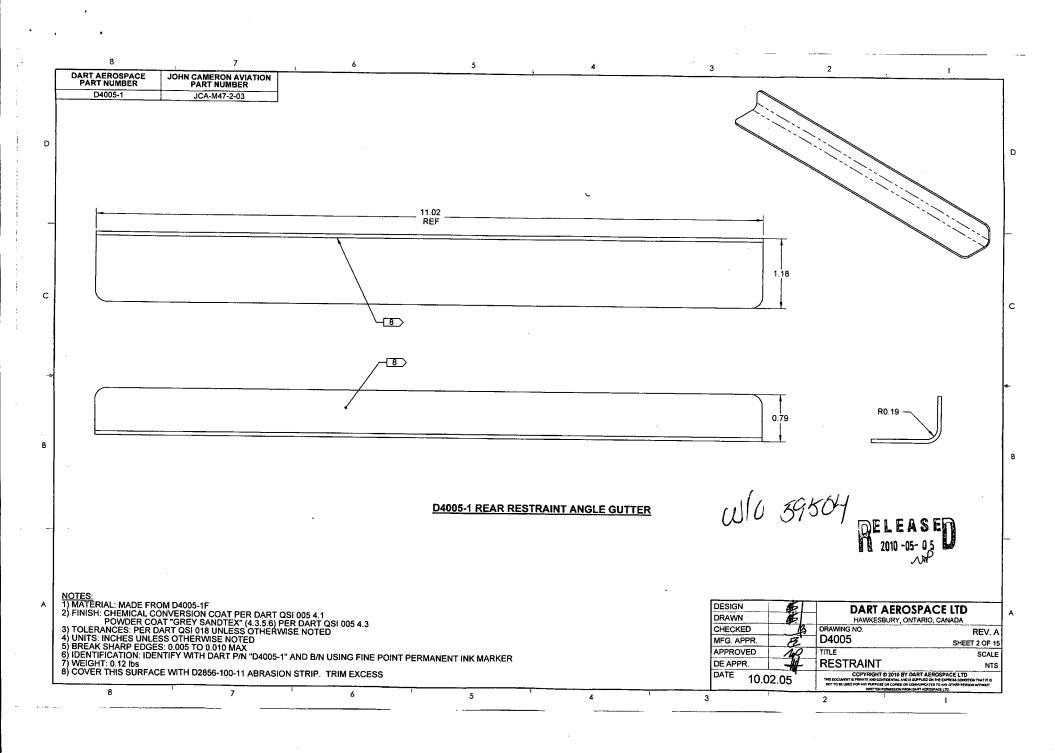
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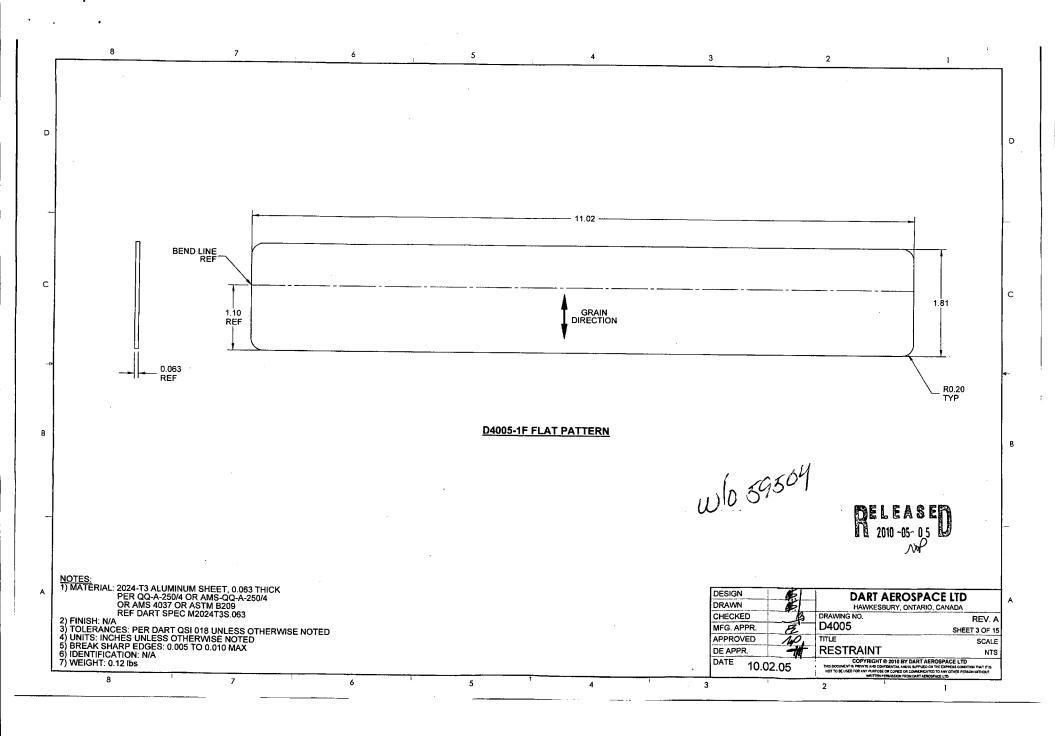
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QTY. -041 ITEM NO. JOHN CAMERON AVIATION PART NUMBER **PART NUMBER** DESCRIPTION SHOP COPY D4005-041 FORWARD FLOOR GUTTER JCA-M47-2-22 RETURN TO ENGINEERING D4005-13 ANGLE UNCONTROLLED COPY D4003-13 TUBE D SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 59504 BS10-6-07 **D4005-041 FORWARD FLOOR GUTTER** NEW ISSUE 10.02.05 REV. DATE DESCRIPTION NOTES: 1) MATERIAL: N/A DESIGN **DART AEROSPACE LTD** 1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER DAT QSI 005 4.2
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4005-041" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.22 Ibs
8) WELD PER DART QSI 004 DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4005 MFG. APPR. SHEET 1 OF 15 APPROVED RESTRAINT DE APPR. COPYRIGHT © 2010 BY DART AEROSPACE LTD
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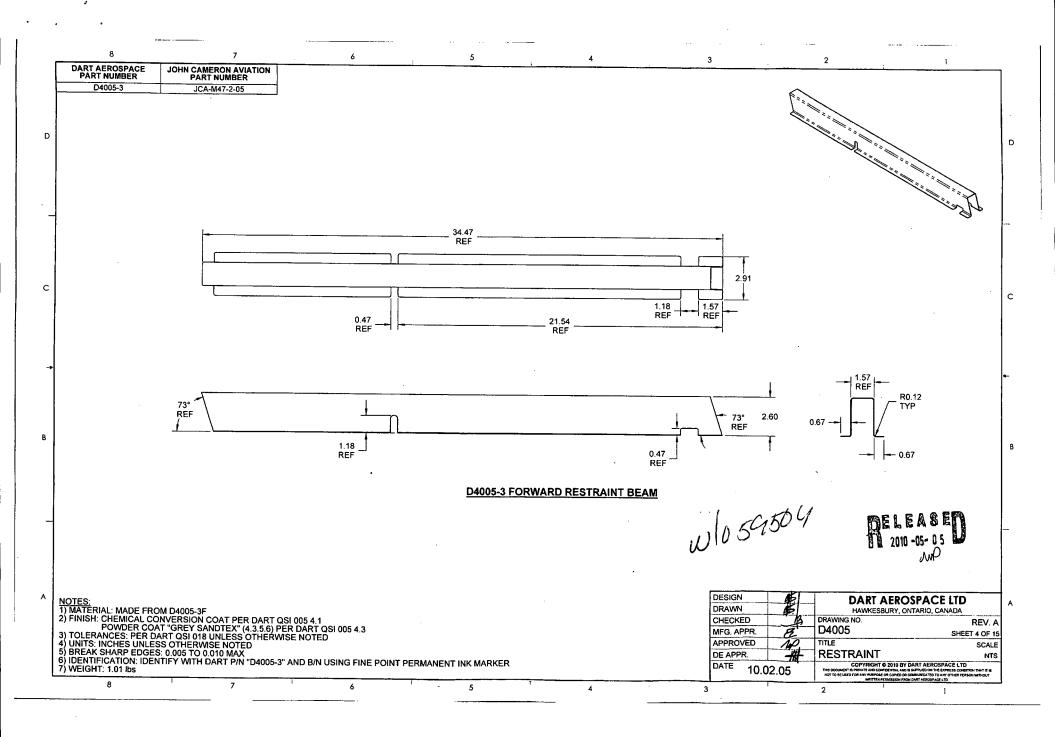
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D D - 0.78 R0.24 R0.12 1.18 -TYP REF С TYP GRAIN ___ 0.78 BEND LINES 3.16 TYP 1.79 0.040 TYP REF 0.66 **D4005-3F FLAT PATTERN** w/559504 NOTES: 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF DART SPEC M2024T3S.040 DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA REF DART SPEC M2024T3S.040
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.01 lbs CHECKED DRAWING NO.

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SCALE

NTS

SHEET 5 OF 15

D4005

RESTRAINT

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TITLE

MFG. APPR.

APPROVED

DATE 10.02.05

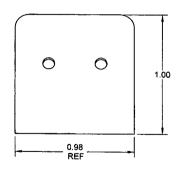
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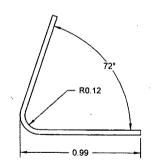
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DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D4005-5 JCA-M47-2-06







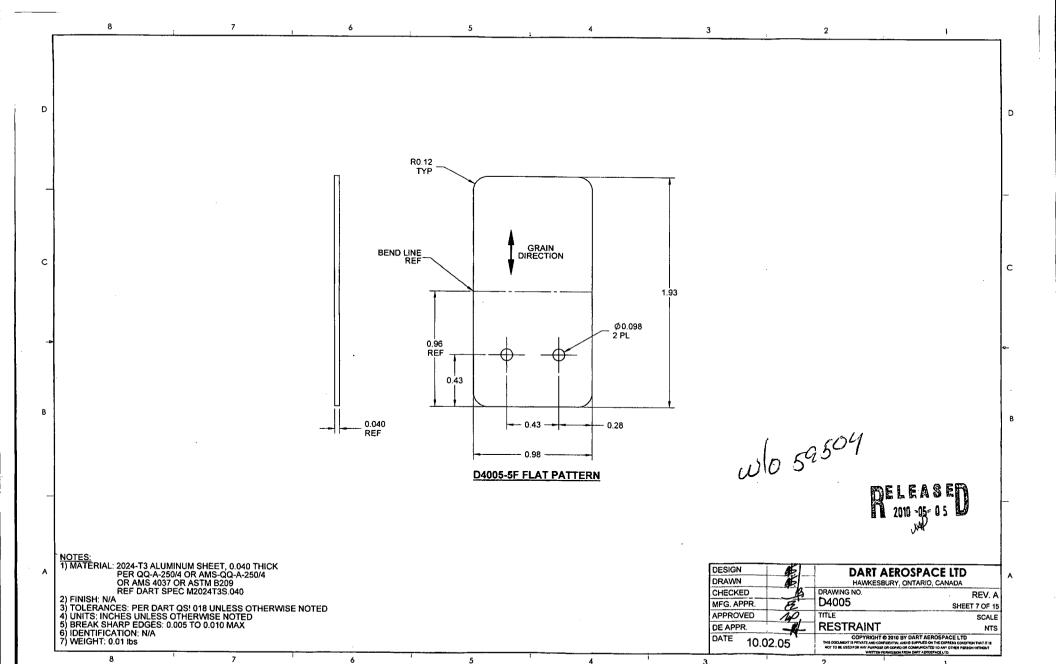
D4005-5 ANGLE

w/o 59504

NOTES: 1) MATERIAL: MADE FROM D4005-5F 2) FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4005-5" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.01 lbs

DESIGN	45	DART AEROS	PACE LTD				
DRAWN	AS	HAWKESBURY, ONT					
CHECKED		DRAWING NO.	REV. A				
MFG. APPR.	E	D4005	SHEET 6 OF 15				
APPROVED	10.	TITLE	SCALE				
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5 2 DART AEROSPACE JOHN CAMERON AVIATION PART NUMBER D4005-7 JCA-M47-2-07 D D 0.98 С 0.98 R0.12 2.09 REF D4005-7 ANGLE MADE FROM D4005-7F DESIGN NOTES:
1) MATERIAL: MADE FROM D4005-7F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4005-7" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.02 lbs DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4005 MFG. APPR. SHEET 8 OF 15 APPROVED TITLE SCALE RESTRAINT DE APPR NTS COPYRIGHT 6 2010 BY DART AEROSPACE LTD
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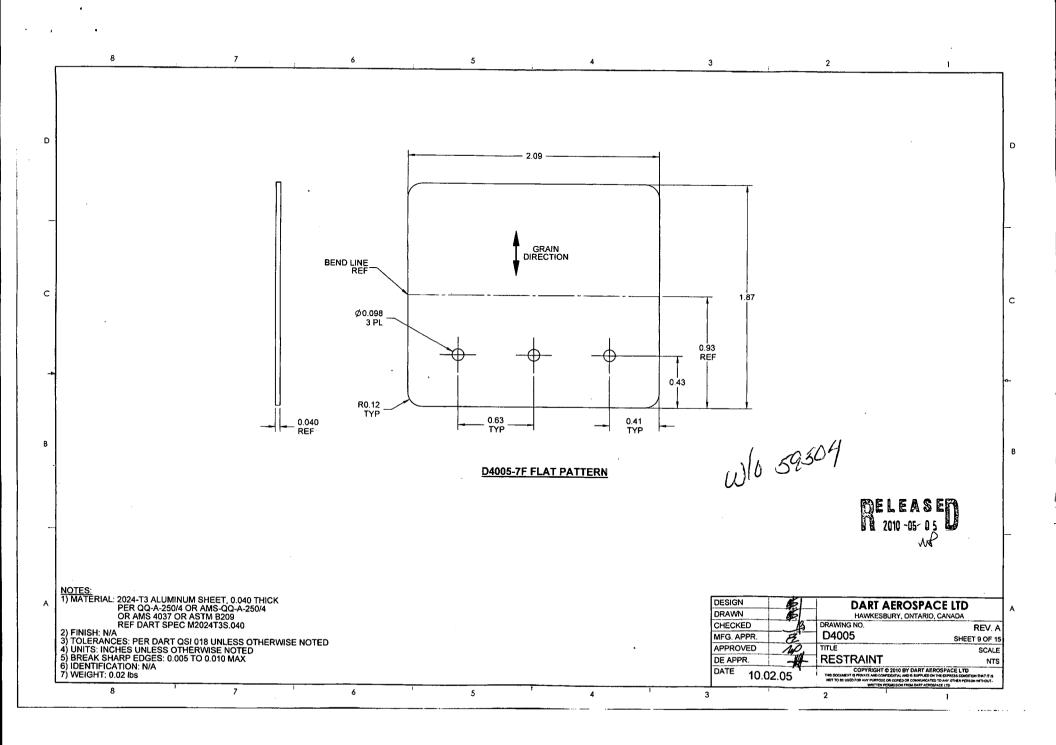
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W/O:		WORK ORDER CHANGES											
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date: _						
	Res	solution:	Disposition	n:	_ QA: N/C Cld	sed:	Date: _						
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCR)							
DATE	STEP	Description of NC		Corrective Action Section		Verification	Approval	Approval					
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector					
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DATE	STEP	Description of NC	· · · · · · · · · · · · · · · · · · ·	Corrective Action Section			cation	Approval	Approval
· · · · · · · · · · · · · · · · · · ·		Section A	Initial Chief Eng	Action Description Chief Eng	Sign a Date		on C	Chief Eng	QC Inspector
									

DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D4005-9 JCA-M47-2-08

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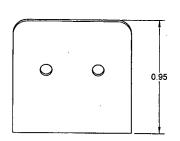
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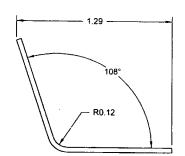


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D4005-9 ANGLE

w/0 39564



	TES:	
1)	MATERIAL: MADE FROM D4005-9	F
21	FINISH: CHEMICAL CONVERSION	üС

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4005-9" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.01 lbs

DESIGN	85	DART AEROS	SPACE LTD			
DRAWN	1	HAWKESBURY, ONTARIO, CANADA				
CHECKED	B	DRAWING NO.	REV. A			
MFG. APPR.	图	D4005	SHEET 10 OF 15			
APPROVED	14	TITLE	SCALE			
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DATE 10.0	2.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PREVATE AND CONTRIBUTION, AND IS RUPPLED ON THE EXPRESS CONTRIBUTION THAT IT IS, NOT TO BE USED FOR ANY PLUMPOSE OR COPY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT				

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W/O:			WORK ORDER CHANGES							
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					QA: N/C Closed: Date:					
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DATE	STEP	Description of NC		Corrective Action Section			Verific	cation	Approval	Approval
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R0.12 0.98 TYP GRAIN DIRECTION BEND LINE 1.91 0.96 REF 0.040 Ø0.098 REF -0.28 - - 0.43 --

D4005-9F FLAT PATTERN

W/0 59504

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NOTES: 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF DART SPEC M2024T3S.040 REF DART SPEC M2024T3S.040
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4005 MFG. APPR. SHEET 11 OF 15 APPROVED TITLE SCALE DE APPR. RESTRAINT COPYRIGHT © 2010 BY DART AEROSPACE LTD

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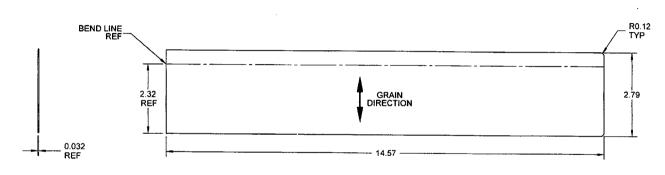
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DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		on C	Chief Eng	QC Inspector	
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3 DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION D4005-11 JCA-M47-2-12 D 2.36 С 14.57 REF R0.10 -0.51 **D4005-11 FINISHING STRIP** w/6 39504 DESIGN DART AEROSPACE LTD NOTES:
1) MATERIAL: MADE FROM D4005-11F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4005-11" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.13 lbs DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4005 MFG. APPR. SHEET 12 OF 15 APPROVED TITLE SCALE DE APPR. RESTRAINT NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD
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	Approval QC Inspector
Part No: PAR #: Fault Category: NCR: Yes No DQA: Date:	
Resolution: Disposition: QA: N/C Closed: Date:	
NCR: WORK ORDER NON-CONFORMANCE (NCR)	
DATE STEP Description of NC Corrective Action Section B Verification Approval	Approval
	QC Inspector
	<u> </u>



D4005-11F FLAT PATTERN

W/0 59804



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NOTES:
1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.032
REF DART SPEC M2024T3S.032
REF DART SPEC M2024T3S.032
REF DART SPEC M2024T3S.032 REF DART SPEC M2024135.032
OR 6061-T6/T62 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS -QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.032
OR 5052-H32 ALUMINUM SHEET
PER QQ-A-250/8 OR AMS-QQ-A-250/8 OR AMS 4016 OR ASTM B209
REF DART SPEC M5052H32S.032 2) FINISH: NIA
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.13 lbs

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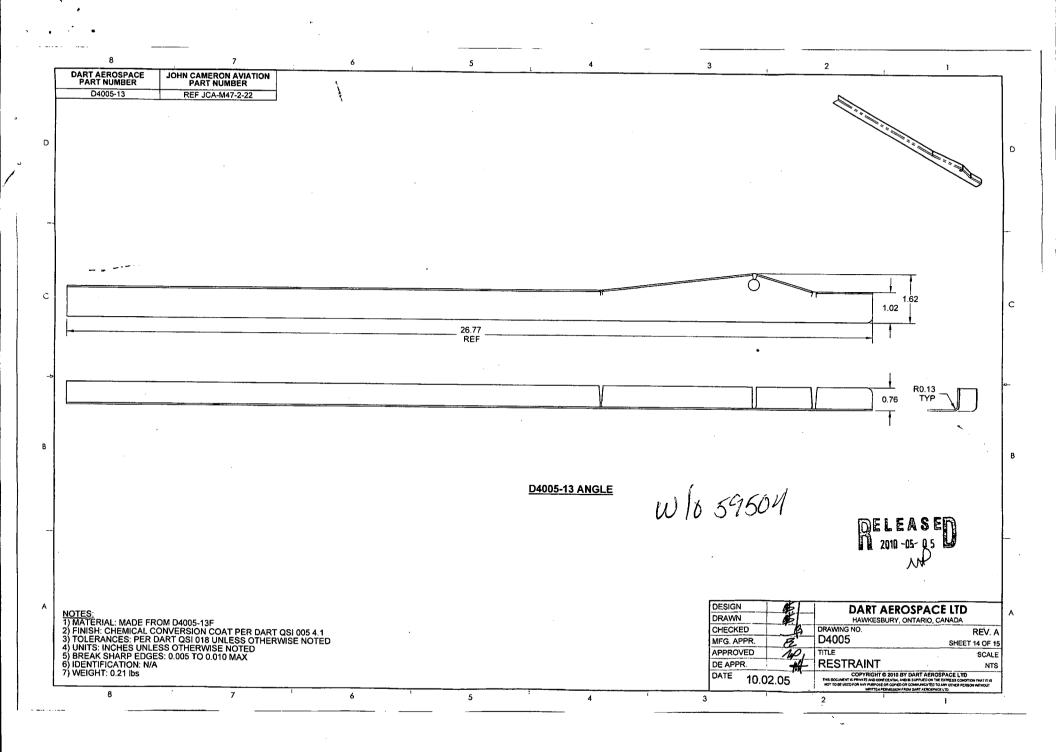
DESIGN	1	DART AEROS	SPACE LTD			
DRAWN	45	HAWKESBURY, ONTARIO, CANADA				
CHECKED	B	DRAWING NO.	REV. A			
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APPROVED	10,	TITLE	SCALE			
DE APPR.	-4/-	RESTRAINT	NTS			
DATE 10.0	2.05	COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS COCUMENT IS PRIVATE AND COMPOBITIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS.				

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DATE	STEP	Description of NC			ion B		Verification		Approval	Approval
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Section		Chief Eng	QC Inspector
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BEND LINE BEND LINE 9.08 R0.38 BEND LINE TYP BEND LINE 0.7Ó REF. TYP **—** 1.87 GRAIN DIRECTION 2.22 2.26 1.67 0.97 REF Ø0:375 -0.040 4.00 REF R0.20 TYP 26.77

D4005-13F FLAT PATTERN

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NOTES: 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF DART SPEC M6061T6S.040 2) FINISH: NIA
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A 7) WEIGHT: 0.21 lbs

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4005 MFG. APPR. SHEET 15 OF 15 TITLE APPROVED SCALE DE APPR. RESTRAINT NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD

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